

Work Order ID 69555



Page 1

Thursday, May 12, 2011 7:46:43 AM

Item ID: D3641-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3641

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

5652.03

1-Cut as per Dwg D3641

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

B 11-5-18

(6)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-5-18

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sullivan

(x6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69555

Thursday, May 12, 2011 7:46:44 AM

Page 2

Item ID: D3641-1

Accept

Revision ID:

Item Name: Cover

Start Date: 5/12/2011 Start Qty: 6.00

Required Date: 5/20/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form as per Dwg D3641-1

SB 11/05/19

(6)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

SB 11/05/19

(46)

150

0.00



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

6X Ø M-L 11/05/24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69555



Page 3

Thursday, May 12, 2011 7:46:44 AM

Item ID: D3641-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 f 22 11/05/20

170

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

11/5/24 60 SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/24 JF
MF
11-05-25

Picklist Print

Thursday, May 12, 2011 7:46:41 AM

Page 1

Work Order ID: 69555



Parent Item: D3641-1



Parent Item Name: Cover

Start Date: 5/12/2011

Required Date: 5/20/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased		No		100	sf	80.0000	0.7987	5.044421			



5052-H32 .032 Sheet



811-5-18

Location

Loc Qty

Loc Code

MAT022

80

100470

2

103321

2

105998

3

108462

5

109478

6

111448

2

112664

16

115638

12

116657

32

116657

(6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>6555</i>
Description: Cover		Part Number: D3641-1
Inspection Dwg: D3641	Rev: B	Page 1 of 1

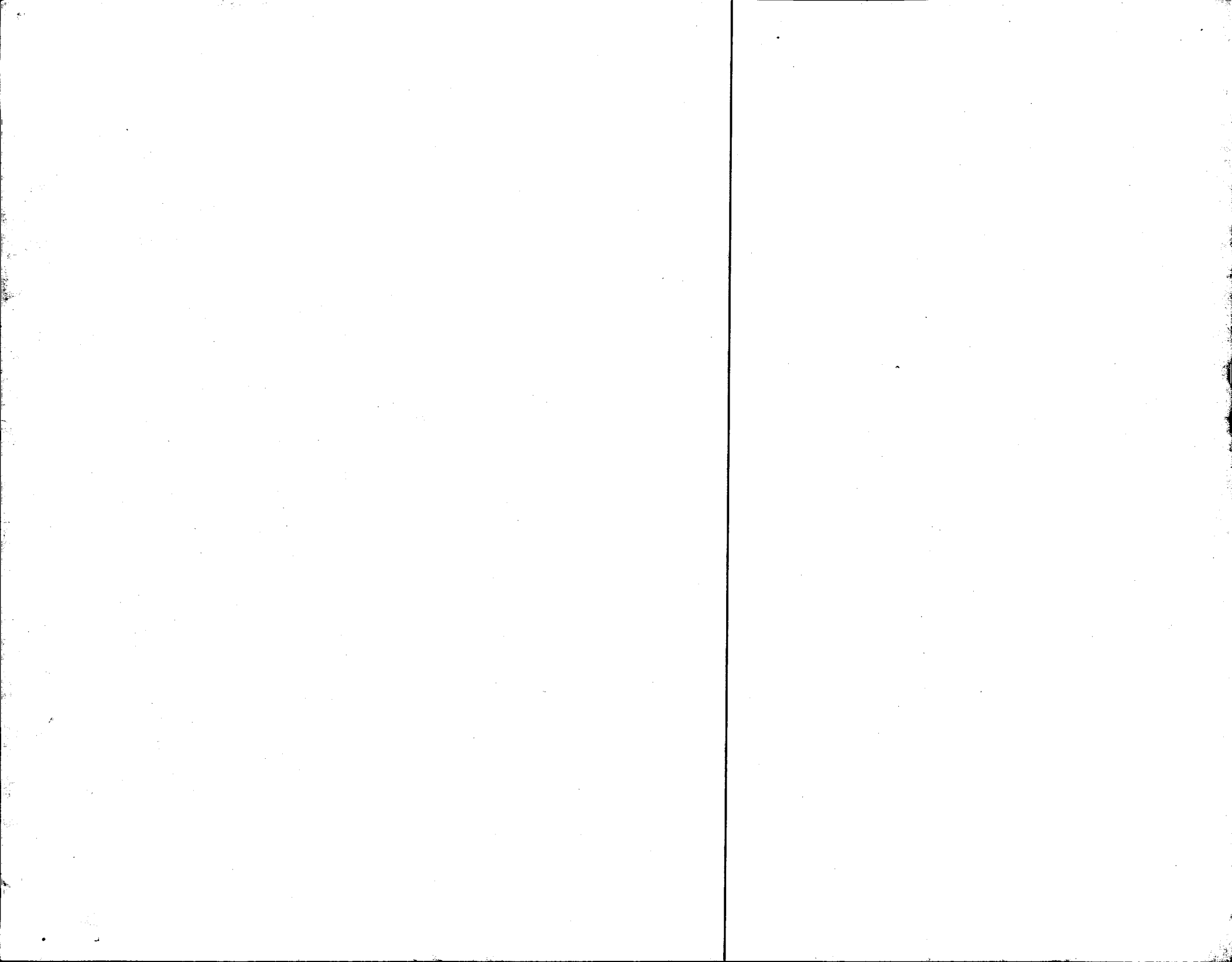
FIRST ARTICLE INSPECTION CHECKLIST

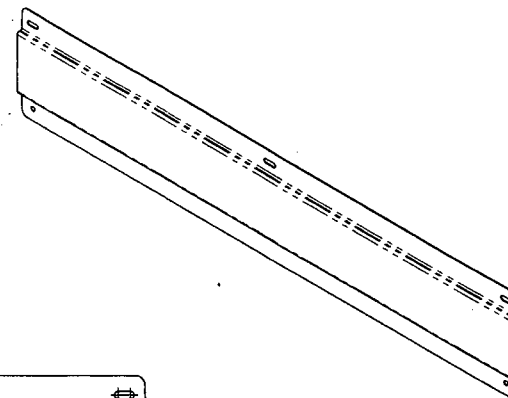
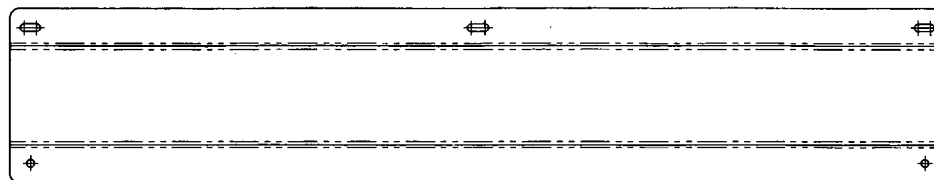
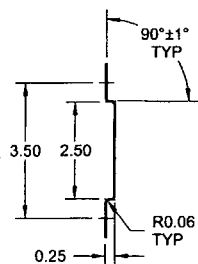
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	.193	>		V 1062	
0.191	+/-0.010	.195	>		V	
0.37	+/-0.030	.37	>		V	
0.54	+/-0.030	.537	>		V	
0.69	+/-0.030	.69	>		V	
11.86	+/-0.030	11.86	>		T 1001	
12.22	+/-0.030	12.22	>		T	
23.37	+/-0.030	23.37	>		T	
23.54	+/-0.030	23.54	>		T	
23.69	+/-0.030	23.69	>		T	
24.06	+/-0.030	24.06	>		T	
0.50	+/-0.030	.500	>		V	
4.28	+/-0.030	4.283	>		V	
4.78	+/-0.030	4.786	>		V	
0.032	+/-0.010	.034	>		V	

Measured by: <i>B</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 11-5-18	Date: 11/05/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<i>[Signature]</i>





D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)
 (MAKE FROM D3641-1F FLAT PATTERN)

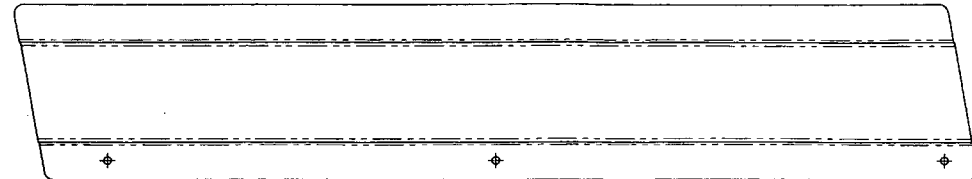
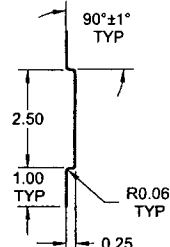
RELEASED
 2009-11-18

NOTES:

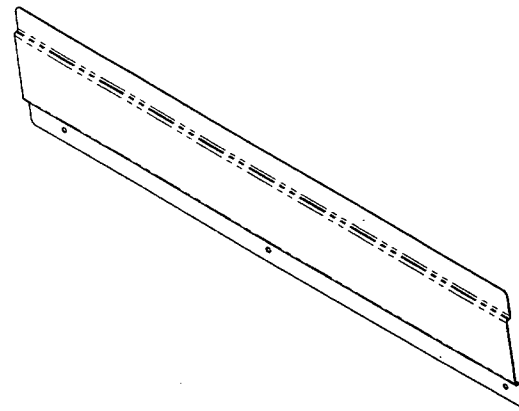
- 1) MATERIAL: D3641-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3641	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER	NTS
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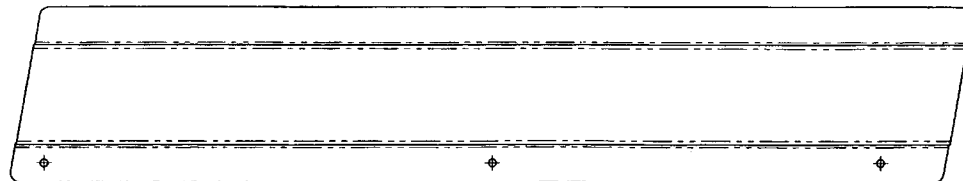
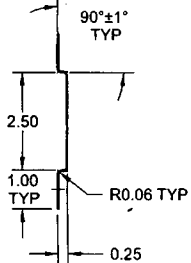
8 7 6 5 4 3 2 1



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
(MAKE FROM D3641-3F FLAT PATTERN)



D3641-3 COVER (SHOWN)
D3641-4 COVER (OPPOSITE)



D3641-4 COVER
(REPLACES GENEVA P/N G10606-4)
(MAKE FROM D3641-3F FLAT PATTERN)

69855

RELEASED
2009-11-10
WPD

- NOTES:
- 1) MATERIAL: D3641-3F FLAT PATTERN
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>JP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JP</i>	D3641	SHEET 2 OF 3
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8 7 6 5 4 3 2 1

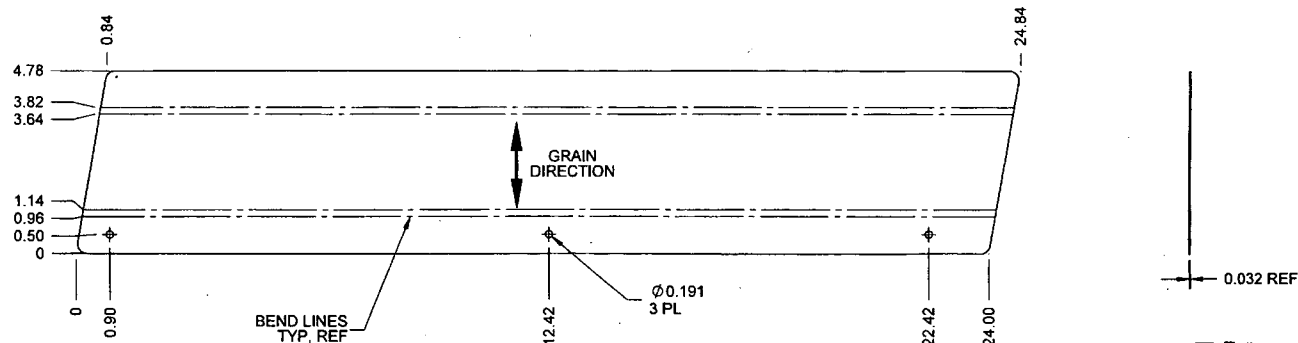
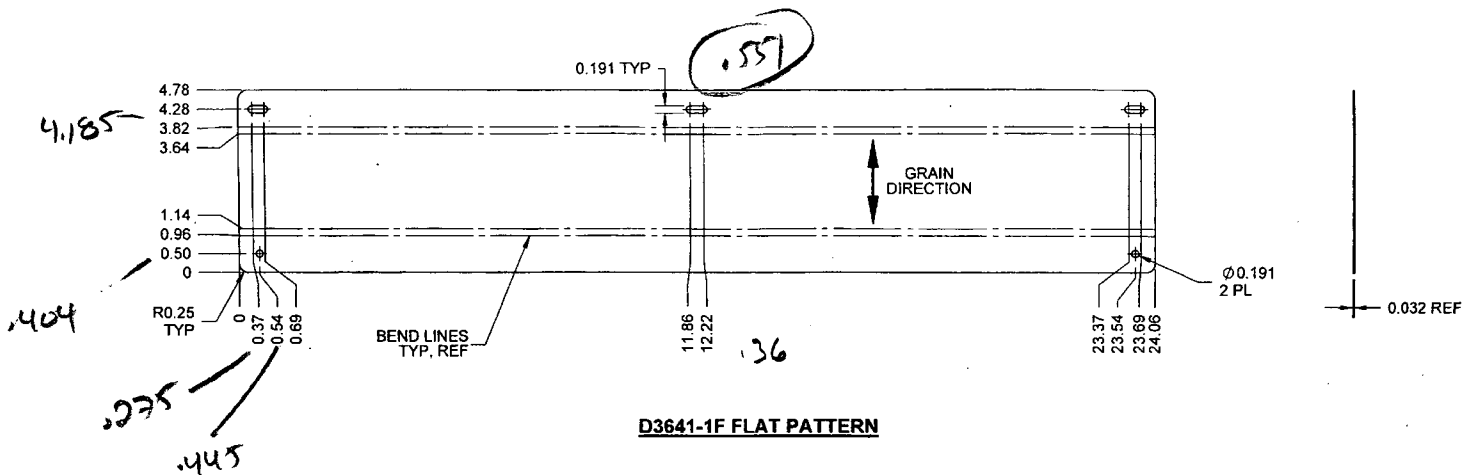
8 7 6 5 4 3 2 1

D

C

B

A



NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1F/-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.36 lbs

RELEASED
2009-11-10

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 3 OF 3
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8 7 6 5 4 3 2 1